

Date: Monday, 05/02/2007 2:28:27 PM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HINGE BRACKET PLATE
<b>Job Number</b> : 30630	
<b>Estimate Number</b> : 10199	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2179
<b>This Issue</b> : 05/02/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2179 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 30630	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : _____	<b>Due Date</b> : 22/02/2007 <b>Qty:</b> 60 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est A 00.07.17 New Issue EC -Est Rev:B Now on Waterjet 07-02-05 JLM	

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S040	5052-H32 .040 Sheet
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**Comment:** Qty.: 0.0096 sf(s)/Unit Total : 0.5733 sf(s)  
Material: 5052-H32 (or 6061-T6) 0.040" thick  
(M5052H32S.040) Batch: *M101875 ml 07 02 28* (60)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D2179  
Dwg Rev: *B ml 07 02 28* (60)  
Prog Rev: *B*  
2-Deburr if necessary *ghy 07/03/07* (60)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE *ml 07 02 28* (60)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK *07/03/01* (60)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1 *m-l 07/03/08* (60x)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M/103141



60x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.H

07/03/08

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

~~07/03/08~~ 60

07/03/08

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/08 60

U

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/09

Job Completion



U 07-03-09

2

Date: Monday, 2/5/2007 8:14:56 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET PLATE
Job Number : 30630	
Estimate Number : 10199	
P.O. Number :	Part Number : D2179
This Issue : 2/5/2007 S.O. No. :	Drawing Number : D2179 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26077	Material :
Written By :	Due Date : 2/9/2007 Qty: 60 Um: Each
Checked & Approved By : <u>07.02.05</u>	
Comment : Est A 00.07.17 New Issue EC	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0096 sf(s)/Unit Total : 0.5733 sf(s)  
Material: 5052-H32 (or 6061-T6) 0.040" thick  
(M5052H32S.040) Batch: \_\_\_\_\_

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut blank: 1.645" x 0.800"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA080 and Dwg D2179  
Identify as D2179

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble and Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:14:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LD Date: 07/03/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

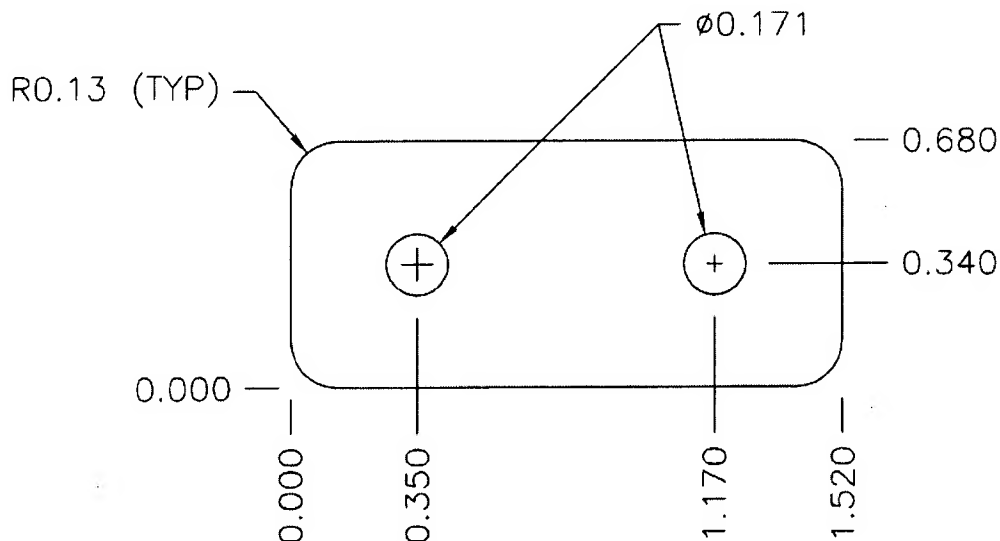






DESIGN KH	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2179	REV. B SHEET 1 OF 1
DATE 00.06.20		TITLE HINGE BRACKET PLATE	SCALE 2:1
A	95.03.17	NEW ISSUE	
B	00.06.20	DWG No. D2179 WAS D2399	

RELEASED  
00.06.27



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)  
OR 2024-T3 (QQ-A-250/4) 0.040 THICK

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 30630

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